

Work Order ID 57111

March 23, 2010 7:43:56 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4083-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 3/23/10

Start Qty: 3.00

Cust Item ID:

Required Date: 3/30/10

Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00

MAT NOT PULLED



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4083

Dwg Rev: 02F

Prog Rev: Lim

2-Deburr if necessary

FAI

10-03-20

10-3-23

304 . 050

ES 10/03/24

19

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-3-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8x9 10/03/24 to perform Dwg only

QC APPROVAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57111

March 23, 2010 7:43:56 AM

Page 2

Item ID: D4083-1

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Item Name: Bracket

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Start Qty: 3.00

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Required Date: 3/30/10

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Bend as per dwg
NC BRAKE

0.00

Brake NC

Memo

D4083 PAZ

0.00

Brake NC

40.03-30 SP 1204/06

9

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Sidoulot ② in PA2 palm Day.
Memo

0.00

QC APPROVAL

Sidoulot ②
to "New A" Day.
Release

150

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

3 SHIP 1204/06
ON ER ERIC D.

1204/06 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57111

March 23, 2010 7:43:57 AM



Page 3

Item ID: D4083-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/23/10

Start Qty: 3.00



Cust Item ID:

Required Date: 3/30/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/10 DJ

W 10-04-16

POSITIVE RECALL

EFFECTIVE 03/23 AUTH W

RELEASED 10.04.16 DATE LS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 23, 2010 7:43:55 AM

Page 1

Work Order ID: 57111



Parent Item: D4083-1

Parent Item Name: Bracket

Start Date: 3/23/10

Required Date: 3/30/10

Comments: IPP Rev:A new issue DD 10.03.11 verified by:EC

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	225.4922	0.1737	16		
304/316 .050 Sheet												

HB 10-3-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

225.4921632

108156

0.98526316

111743

23.7174

112885

72.7895

113062

128

112178

112178

⑨

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

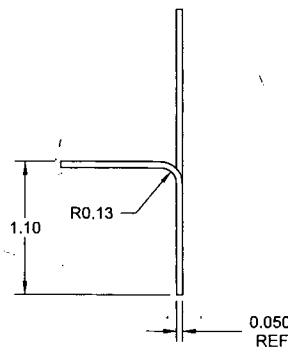
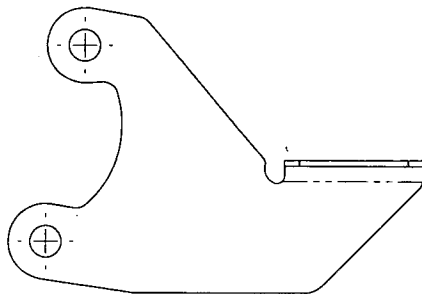
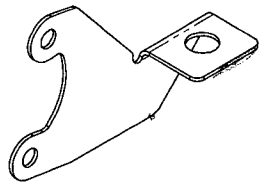
DART AEROSPACE LTD		Work Order:	57111
Description: BRACKET		Part Number:	D4083-1
Inspection Dwg: D4083-1 Rev: PA1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

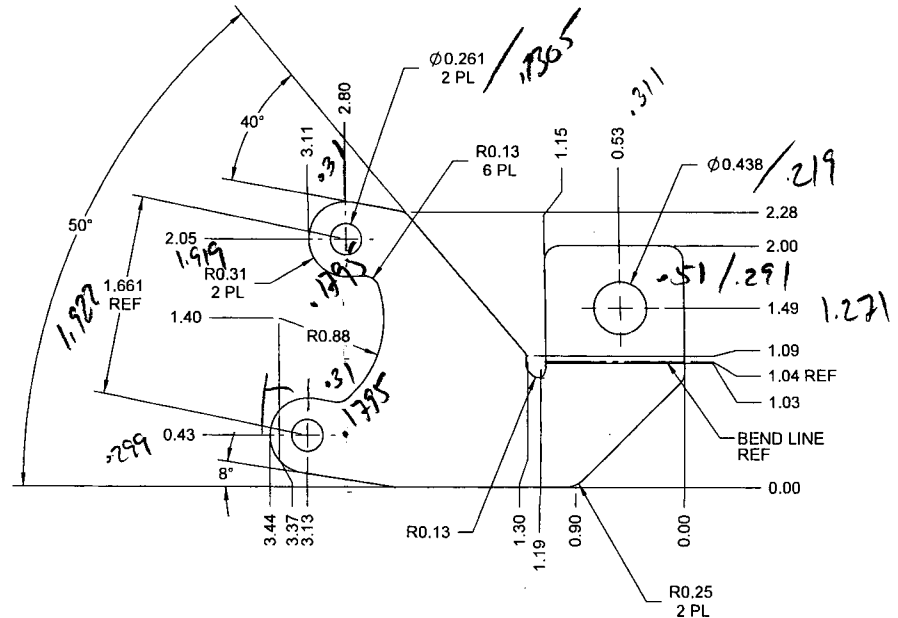
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .261	+ .006 - .001	.266	✓			
Ø .438	+ .006 - .001	.433	✓			
.53	± .030	.532	✓			
1.15	± .030	1.150	✓			
2.86	± .030	2.800	✓			
3.11	± .030	3.113	✓			
3.13	± .030	3.130	✓			
3.37	± .030					
3.44	± .030	3.446	✓			
.43	± .030	.433	✓			
2.05	± .030	2.052	✓			
1.661	± .010	1.663	✓			
1.49	± .030	1.491	✓			
2.00	± .030	2.002	✓			
2.28	± .030	2.260	✓			
.050	± .010	.046	✓			

Measured by: KB	Audited by: S	Prototype Approval:	N/A
Date: 10-3-03	Date: 10/03/26	Date:	N/A
Revised by		Approved	
Rev A	Date	Revised by KJ/JLM	Approved
Change New Issue			



D4083-1 BRACKET
(MAKE FROM D4083-1F FLAT PATTERN)



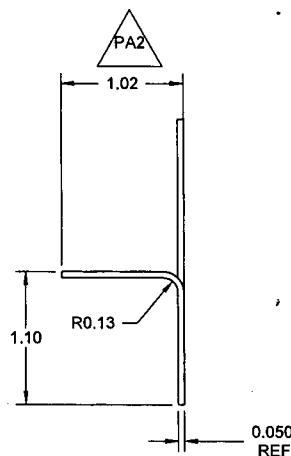
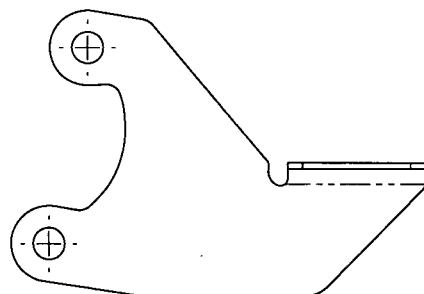
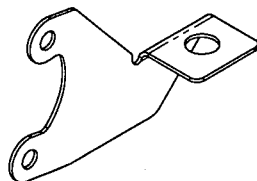
D4083-1F FLAT PATTERN

NOTES:

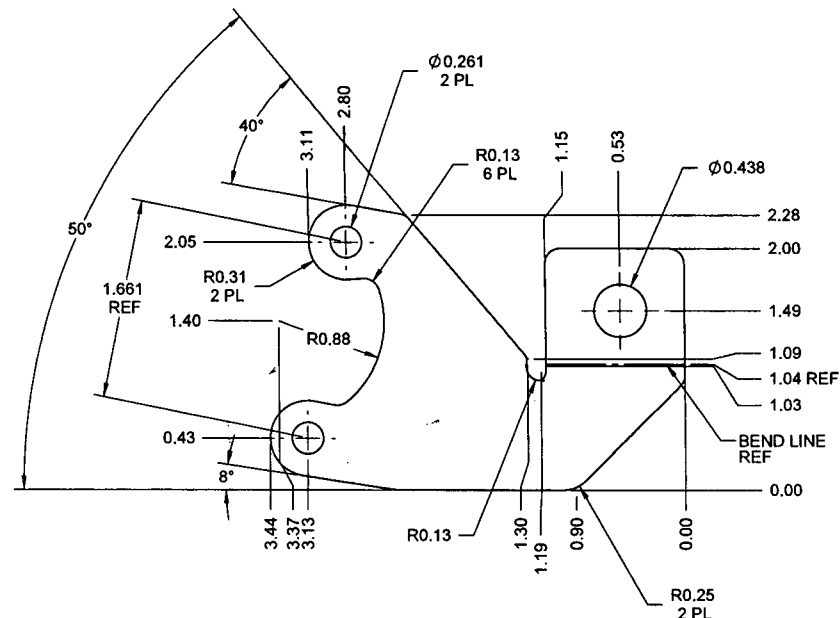
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4083-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

WLU 57111

PA1	NEW ISSUE	RF	10.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4083	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.03.19	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4083-1 BRACKET
(MAKE FROM D4083-1F FLAT PATTERN)



D4083-1F FLAT PATTERN

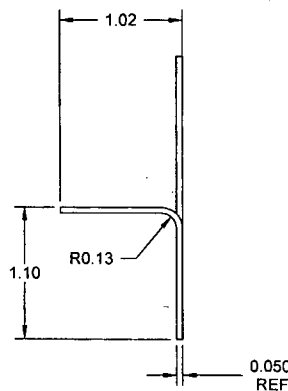
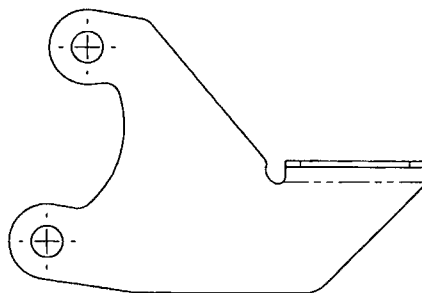
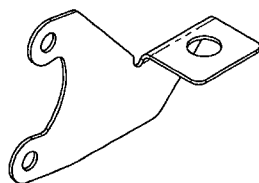
NO CHANGE FROM
PA1 1310.03.30

NOTES:

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W/O 57111

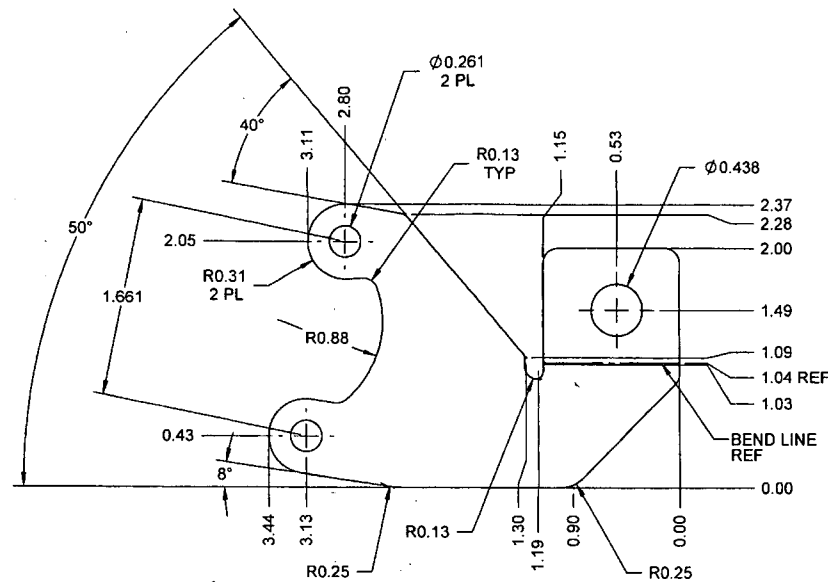
PA2	ADD DIMENSION 1.02 (ZN C5-1)	RF	10.03.30
PA1	NEW ISSUE	RF	10.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4083	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.03.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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(MAKE FROM D4083-1F FLAT PATTERN)

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OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
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- 7) WEIGHT: 0.01 lbs



D4083-1F FLAT PATTERN

*No orig
From D41/P12*
RELEASED
2010-04-14
MD

57111

A		NEW ISSUE		RF	10.04.13
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4083 BRACKET			
DRAWN	RF				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.		DATE 10.04.13			
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